

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 4914 (1983): Tap Wrenches, Adjustable [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



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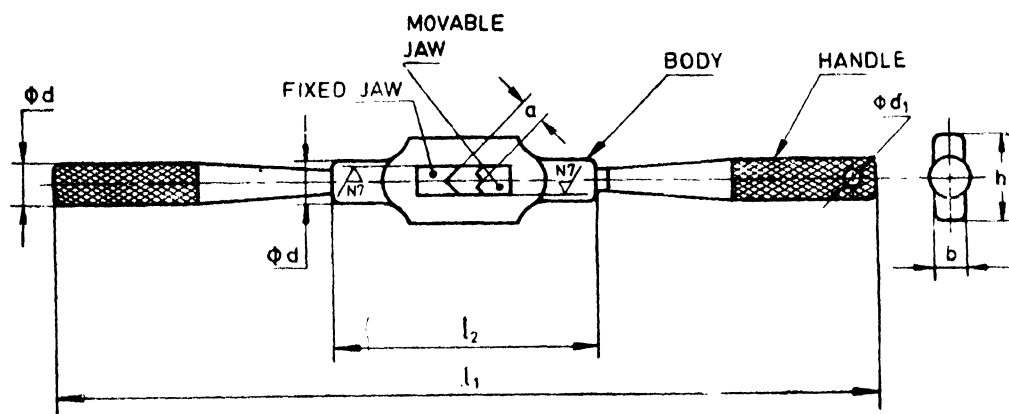


**AMENDMENT NO. 1 MAY 1990**  
**TO**  
**IS : 4914 - 1983 SPECIFICATION FOR TAP**  
**WRENCHES, ADJUSTABLE**

( *First Revision* )

( *Page 1, clause 2, Fig.* ) — Substitute the following for the existing figure:

$\nabla 9 / ( \nabla 7 )$



NOTE :  $\phi d_1$  shall be approximately one third of handle dia, rounded off to nearest whole number.

( PE 13 )



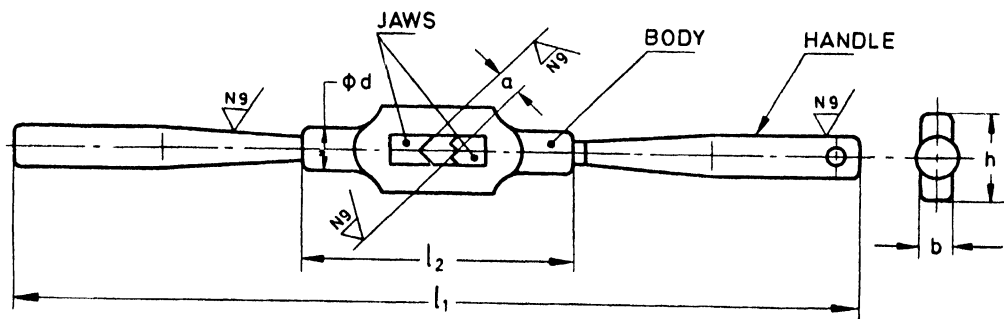
Indian Standard

SPECIFICATION FOR  
TAP WRENCHES, ADJUSTABLE

( First Revision )

1. **Scope** — Covers the dimensions and requirements for adjustable tap wrenches.

2. **Dimensions**



All dimensions in millimetres.

Size	Range of Square <i>a</i>		<i>b</i>	Tolerance on <i>b</i>	<i>d</i>	Tolerance on <i>d</i>	<i>h</i> Max	<i>l</i> <sub>1</sub> Max	<i>l</i> <sub>2</sub> Max
	From	To							
0	2	5	7	±1	10	±0.5	20	125	56
1	2	6	8		12		24	180	75
2	4	9	11		15		32	280	106
3	4.9	12	16	±2	20	±1	45	375	140
4	5.5	16	22		26		60	500	180
5	7	20	28		30		67	750	200
6	9	25	31		33		85	1000	250
7	16	32	34		36		85	1250	300

**Note** — The figure is indicative of dimensions and does not specify design features.

3. **Material**

**Jaws** : Steel having tensile strength not less than 400 MPa\*

**Handles and Body** : Malleable cast iron according to IS : 2107-1977 'Whiteheart malleable iron casting' or IS : 2108-1977 'Blackheart malleable iron casting'.

**Note** — The handles and body up to  $a = 5.5$  to 16.0 mm may be made of zinc alloy die casting also according to IS : 742-1966 'Zinc base alloy die castings'.

\*1 MPa = 0.1 kgf/mm<sup>2</sup> (approx).

Adopted 27 July 1983

© October 1983, ISI

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INDIAN STANDARDS INSTITUTION  
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NEW DELHI 110002

# **IS : 4914 - 1983**

## **4. Hardness**

Jaws (Working surface) : 600 HV Min  
660 HV Max

## **5. General Requirements**

**5.1** The tap wrenches having suitable arrangement for adjusting the size of square, shall be robust in constructions and positive in locking.

**5.2** Handles shall be in good alignment.

**5.3** All edges shall be chamfered.

**5.4** Outer half of handles, with overall length 500 mm and above, shall be knurled.

**6. Designation** — An adjustable tap wrench having size 4 and conforming to this standard, shall be designated as :

Tap Wrench 4 — IS : 4914

## **7. Marking**

**7.1** The tap wrenches shall be marked with the size, range of square (*a*) and the manufacturer's name, initials or trade-mark.

**7.2 ISI Certification Marking** — Details available with the Indian Standards Institution.

**8. Sampling** — The sampling and criteria of acceptance shall be in accordance with IS : 7778-1975 'Methods for sampling small tools'.

## **9. Protective Coating and Packing**

**9.1** Each wrench shall be covered with a rust-proofing material and wrapped in non-absorbent paper.

**9.2** Each wrench or number of wrenches shall then be protected by a cover bearing the range of square *a*, and manufacturer's name, initials or trade-mark.

**9.3** Only one size of wrenches shall be packed in a carton.

## **EXPLANATORY NOTE**

This standard was first published in 1968. This revision is being necessitated to bring it in line with the developments in the intervening period.

In the preparation of this standard considerable assistance has been derived from DIN 1814-1979 'windeisen einstellbar (Tap wrenches, jaws moveable)', issued by Deutsches Institut für Normung (DIN).

Further, IS : 4917-1968 'Tap wrenches, fixed' is being withdrawn, there is not much use of fixed tap wrenches in the country and adjustable wrenches can serve both the requirements.